Work Orde September-20-12	er ID 90571 2 7:48:25 AM		*90571*								Page 1
Item ID: Revision ID:	D2013-1		Accept	*N900	1040	100)*	Setup	Start	*N:	S1*
	Mirror Bracket LH, 205								Stop	*//	S2*
	9/18/12 Start Qty: 4	.00 *4*		Cust Iten	ı ID:					1 12 1	. 17
Required Date: Reference:	10/12/12' , Req'd Qty: 4	.00 *4*		Customer	r:						
Approvals:	Process Plan: ML5	Date: 12-09-20	Tooling:		Date:			Run	Start	*N	R1*
	QC:	Date:	SPC (Y/N):		Date:				Stop	*N	R2*
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject : Number	Insp. Stamp
Draw Nbr	Revision Nbr									., ., ., ., ., ., ., ., ., ., ., ., ., .	
D2013	Rev C										
100			0.00			<u> </u>					FF
100	NC BRAKE						-4	Ø		· .	01-02-
Brake NC	Men		0.00				1	7			
Brake NC	2-Fla 3-Be	nch as per template D2013-T1and I tten ends of D2013-1 tube as per D nd (1) tube as per Dwg D2013 using burr as required	wg D2013 using DT85								
(-110	QC5- Inspect par	t completeness to step on W/O	0.00	3)							
110 _{QC}	Men	,	0.00	0103			4			n	
Quality Control											
120	Identify as per dv	vg & Stock Location: W/+ 00/	0.00						A)		
120 Packaging Packaging	Men	10	0.00				(T)		4	13-1	3

NCR:	Yes	/ No				WORK ORDER NON-O							
14011.		, 110									QA Closed:	Date	
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIK OIG	٠١٠.					Rework	Skid-tube Crosstube			Crosstube		Engineering	
Part I	No.					Scrap	1		Machining	Small Fab	Pro	Quality	
	•					Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	۷o.					Work Order Update]		Large Fab	Composite	Supplier		
Root		· · · · · · · · · · · · · · · · · · ·	l .		Descri	ption of work order update	<u> </u>	nitial	Act	ion	Sign &		T
Cause		Date	Step	Qty	1	or Non-conformance	1	ief Eng		ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling									1				
Operator													
Material	Ш												
Setup	Ш						ŀ						·
Other	Щ								1				
Process	igsqcup						l						
Supplier	Ш												
Training													
Unapproved			İ	<u> </u>				TCATE	CODY		1		
l a a di						General	AUI	T CATE	GURY				
Landi	ng (Bending				Bend		Grain			Ovalized	Г	Pressure/Forced
	-	Centre No	nt Conce	ntric to		BOM/Route	-	Hardwa	aro	<u> </u>	Over/Under	tolerance	Temperature/Cure
		Cracks	or conce	itile to	· -	Broken/Damaged	-	4	ion Incomplete	<u> </u>	Part Incorre		Weld
	\vdash	Crushed/	Crimped		-	Burrs	\vdash	1	tions Incomplete/l	Jnclear 📙	Part Lost/M	⊢	Wrong Stock Pulled
	$\overline{}$	Cuffs	e.m.pea.		<u> </u>	Contamination	\vdash	4	enance	-	Part Moved	· -	
	-	Heat Trea	at .			Countersink		Mislabe			Positioned \		
	\vdash	Inspectio		Tube		Cut Too Short		Misrea		-	Power Loss,		Other
	_	Ripples in				Drill Holes		Offset		<u> </u>	_	<u>-</u>	- L
		Torque W		xtrusio	n	Drawing		Out of	Calibration				
		Turning Sequence				Finish		Out of	Sequence				

Outside Dimensions

Date:

DQA:

Wave/Twist in Tube

Folio

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Work Order ID 90571 September-20-12 7:48:25 AM D2013-1 Accept *N900040100* Item ID: Setup Start **Revision ID:** Item Name: Mirror Bracket LH, 205 *4* Start Qty: 4.00 **Start Date:** 9/18/12 **Cust Item ID: Req'd Qty:** 4.00 Required Date: 10/12/12 **Customer:** Reference: Run **Tooling:** Date: Approvals: Process Plan: Date: Stop Date: SPC (Y/N): QC: Date: Sequence ID/ Tool ID Tool # Plan Reject Set Up/ Reject **Operation** Accept Work Center ID Qty Description Qty Number **Run Hours** Code

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

130

QC

130

Quality Control

U 13-81.03

Page 2

Insp.

Stamp

Yes ,	/ No				WORK ORDER NON-O	CON	NFOR!	л <mark>ance / upd</mark> at	E .			-
										QA Closed:	Date	2:
er:					DISPOSITION			Þ	AGAINST DEF	PARTMENT	PROCESS	
Part No					Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite			imall Fab Finishing		Engineering Quality Other		
	Date	Sten	Otv		•	1		Action Descriptio	on	Sign & Date	Verification	QC Inspector
ng Ge	ar	,			**************************************	AUL	.I CATE	3011				
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Inspecti Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/Uncle enance eled		Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
	ng Ge	ng Gear Bending Centre No Cracks Crushed/C Cuffs Heat Trea Inspection Ripples in	Date Step Date Step Qty Date Step Qty Date Step Qty Date Step Qty Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend	ng Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube	Price Step Disposition Rework Scrap Use-as-is Work Order Update Date Step Qty Description of work order update Or Non-conformance Rework Scrap Use-as-is Work Order Update Or Non-conformance Rework Scrap Use-as-is Work Order Update Or Non-conformance Rework Scrap Use-as-is Work Order Update Or Non-conformance Remork Scrap Use-as-is Use	Part Pa	Primary Contamination Price Price	Part Disposition Rework Skid-tube Crosstube Machining Small Fab Large Fab Composite Thermoforming Finishing Large Fab Composite Thermoforming Thermoforming Composite Thermoforming Thermoforming Composite Thermoforming Thermofo	Procession of work order update or Non-conformance Chief Eng Description Date Description Description Date Description Date Description Date Description Description Date Description Description Date Description Description Date Description Description	AGAINST DEPARTMENT/PROCESS Rework Scrap Use-as-is Work Order Update Date Step Qty Or Non-conformance Step Qty Or Non-conformance Centre Not Concentric to O/S BoM/Route Centre Not Concentric to O/S Cracks Broken/Damaged Inspection Incomplete Cracks Broken/Damaged Inspection Incomplete Instructions Incomplete Instructions Incomplete Instructions Incomplete Under Inspection Strip in Tube Contamination Maintenance Part Lost/Missing Cut Too Short Missead Power Loss/Surge Reposed Fower Lost/Surge Inspection Strip in Tube Cut Too Short Missead Offset		

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence
Wave/Twist in Tube

Finish

Folio

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Picklist Print

September-20-12 7:48:25 AM

Work Order ID:

90571

Parent Item:

D2013-1

Parent Item Name:

Mirror Bracket LH, 205

Start Date: 9/18/12

Required Date: 10/12/12

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A

New Issue 05-11-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	639.1204	1.9473	8.199158			
304 RD Tube .750 x .049V	V								(· · · · · · · · · · · · · · · · · · ·	-SAU-	/d	-11-	01
				Location		Loc Qty	Lo	c Code					
				MAT017		639.120417							
				1093	14	9.333							
				1116	19	3							
				1121	87	4							
				1128	300	11							
				1148	352	2.75							
				1161	08	3							
				1177	97	0.75							
				1204	41	0.000794							
				1211	70	234.89	•						
				1216	666	10.232							
				1223	12	87.19			_				
				1224	68	272.974623			3.1	992			

										DQA:	Date:				
NCR: Y	'es	/ No				WORK ORDER NON-C	CONFORM		QA Closed:	Date:					
Work Order:						DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Part No				Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other				
Root					Descri	ption of work order update	Initial	Act	tion	Sign &		1			
Cause		Date	Step	Qty	٠ (or Non-conformance	Chief Eng	Desci	ription	Date	Verification	QC Inspector			
Doc/Data				100											
Equip/Tooling					•	i .									
Operator			•				1								
Material															

Lanc	ing	Gear	General	 _			_
		Bending 💝	Bend	Grain	Ovalized		Pressure/Forced
profession and the second		Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Ĺ	Temperature/Cure
		Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect		Weld
		Crushed/Crimped	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing		Wrong Stock Pulled
		Cuffs	Contamination	Maintenance	Part Moved		
ļ		Heat Treat	Countersink	Mislabeled	Positioned Wrong		_
Ì		Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge	L	Other
4.		Ripples in Bend	Drill Holes	Offset			
73		Torque Waves in Extrusion	Drawing	Out of Calibration			
	L	Turning Sequence	Finish	Out of Sequence			
		Wave/Twist in Tube	Folio	Outside Dimensions			

FAULT CATEGORY

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Setup
Other
Process
Supplier
Training
Unapproved

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